

What is claimed is:

1. A Sawtooth wire for producing all-steel sawtooth clothing for a doffer and/or a doffing cylinder of a carding machine, the sawtooth wire comprising a plurality of teeth successively arranged in a longitudinal direction of the wire, each tooth having a tooth breast beginning at a tooth bottom and extending in a direction toward a tooth tip, and a tooth back that is connected with the tooth breast by two tooth flanks extending parallel to the longitudinal direction of the wire and extends from the tooth tip in a direction of a tooth bottom of a following tooth, at least one of the tooth flanks having at least one profile segment located between the tooth tip and the tooth bottom and provided with profiling.
2. The sawtooth wire in accordance with Claim 1, wherein the profile segment has at least one of at least one profile ridge and at least one profile groove.
3. The sawtooth wire in accordance with Claim 2, wherein

the profile ridge runs substantially parallel to the longitudinal direction of the wire.

4. The sawtooth wire in accordance with Claim 2, wherein the profile groove runs substantially parallel to the longitudinal direction of the wire.
5. The sawtooth wire in accordance with Claim 2, wherein the at least one of the profile ridge and the profile groove has an arc-shaped border at least in certain sections in a sectional plane that runs perpendicularly to a longitudinal direction of at least one of the profile ridge and the profile groove.
6. The sawtooth wire in accordance with Claim 5, wherein the arc-shaped border section has a radius of curvature in a range of 0.05-0.5 mm, preferably 0.1-0.3 mm, and especially about 0.15 mm in a sectional plane running perpendicularly to the longitudinal direction of the at least one of the profile ridge and the profile groove.
7. The sawtooth wire in accordance with claim 6, wherein the radius of curvature is in a range of 0.1-0.3 mm.

8. The sawtooth wire in accordance with claim 7, wherein the radius of curvature is about 0.15 mm.
9. The sawtooth wire in accordance with claim 2, wherein the profile segment has a plurality of profile grooves running substantially parallel to the longitudinal direction of the wire, and the profile groove has a lesser profile depth than an adjacent profile groove located on a side of the profile groove facing the bottom of the tooth.
10. The sawtooth wire in accordance with claim 2, wherein an essentially flat transition segment is located between at least two adjacent profile ridges or grooves of a profile segment.
11. The sawtooth wire in accordance with Claim 10, wherein a transition between the transition segment and at least one adjacent profile ridge or one adjacent profile groove is rounded with a radius of curvature in a range of 0.01-0.05 mm.

12. The sawtooth wire in accordance with claim 11, wherein the transition has a radius of curvature of about 0,02 mm.
13. The sawtooth wire in accordance with claim 2, wherein the profile ridge and the profile groove respectively have a profile height and a profile depth of at least 0.02 mm.
14. The sawtooth wire in accordance with claim 13, wherein the profile height and the profile depth are at least 0.04 mm.
15. The sawtooth wire in accordance with claim 14, wherein the profile height and the profile depth are at least 0.05 mm.
16. The Sawtooth wire in accordance with claim 2, wherein individual profile grooves and profile ridges of a profile segment are separated from one another by a distance in a range of 0.1-0.6 mm.
17. The Sawtooth wire in accordance with claim 16, wherein

individual profile grooves and profile ridges of a profile segment are separated from one another by a distance in a range of preferably 0.2-0.4 mm.

18. The Sawtooth wire in accordance with claim 17, wherein individual profile grooves and profile ridges of a profile segment are separated from one another by a distance of about 0.3 mm.
19. The sawtooth wire in accordance with claim 1, wherein, in at least one tooth, both tooth flanks have at least one profile segment so that the profile segment located on one of the tooth flanks is staggered relative to the profile segment located on the other tooth flank in a height direction of the tooth extending from the bottom of the tooth to the tip of the tooth.
20. The sawtooth wire in accordance with Claim 19, wherein at least one of the profile segment located closer to the bottom of the tooth has at least one profile groove, and the profile segment located closer to the tip of the tooth has at least one profile ridge.

21. The sawtooth wire in accordance with claim 1, wherein at least one tooth tapers from the bottom of the tooth to the tip of the tooth in a sectional plane running perpendicularly to the longitudinal direction of the wire.
22. The sawtooth wire in accordance with claim 1, wherein each tooth tapers from the bottom of the tooth to the tip of the tooth in a sectional plane running perpendicularly to the longitudinal direction of the wire.
23. The sawtooth wire in accordance with claim 1, wherein the tooth back of at least one tooth has at least one convex segment that passes over into a concave segment in a direction of the bottom of the tooth.
24. A method for producing a sawtooth wire comprising a plurality of teeth successively arranged in a longitudinal direction of the wire, each tooth having a tooth breast beginning at a tooth bottom and extending in a direction toward a tooth tip, and a tooth back that is connected with the tooth breast by two tooth flanks

extending parallel to the longitudinal direction of the wire and extends from the tooth tip in a direction of a tooth bottom of a following tooth, at least one of the tooth flanks having at least one profile segment located between the tooth tip and the tooth bottom and provided with profiling, comprising the steps of: forming a starting material into a wire that has a blade section; and then stamping sawteeth into the blade section, the forming step including profiling the blade section.

25. A doffer and/or doffing cylinder for a carding machine with all-steel sawtooth clothing produced with a sawtooth wire comprising a plurality of teeth successively arranged in a longitudinal direction of the wire, each tooth having a tooth breast beginning at a tooth bottom and extending in a direction toward a tooth tip, and a tooth back that is connected with the tooth breast by two tooth flanks extending parallel to the longitudinal direction of the wire and extends from the tooth tip in a direction of a tooth bottom of a following tooth, at least one of the tooth flanks having at least one profile segment located between the tooth tip and the tooth bottom and provided with profiling.